

# Work Order ID 50235

July 14, 2009 10:31:06 AM



Page 1

Item ID: D2857-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Hinge Bracket

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

*09.07.16*

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2857

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 5.2"

*09/07/24*

*12 0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2857-1112-Deburr any rough edges

*09/07/25*

*12 1*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*09/07/25*

*PTO*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2857-1 PAR #: N/A Fault Category: Prod. Eng. Coord NCR: Yes No DQA:   Date: 09.06.05  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed:   Date: 09.06.15

NCR: <u>50235</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/25	110	One part after set up came too thin at the dimension of .147" came out at .131.	<u>Alt</u> <u>09.07.27</u> <u>QSS</u> <u>042</u>	Section w/ deviation is structural Not acceptable recommend scrap and replace	<u> </u> <u>09/07/25</u>	<u>S</u> <u>09/08/26</u>	<u>Alt</u> <u>09.07.27</u> <u>QSS</u> <u>042</u>	<u>S</u> <u>07/07/27</u>
		R.C. Program error tool go too low.		110936 <u>H</u>				

NOTE: Date & initial all entries

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Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

J.L 09/07/27

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

BR 09-07-28 (12)

Memo

0.00

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> 802/07/08 (12) f

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50235

July 14, 2009 10:31:06 AM



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Item ID: D2857-1

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Setup Start



Revision ID: B

Stop



Item Name: Hinge Bracket

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:30am OVEN TEMPERATURE:

8:00am FINISH TIME: 320°F

M112148

09-07-29

X12

28

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-07-29

(12)

180

Identify as per dwg & Stock Location: 51

0.00



Packaging

Memo

0.00

Packaging

6/9/29 (12)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50235



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Required Date: 7/15/09

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

09/07/29 *HS*

29-07-09 *BR*



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

July 14, 2009 10:31:05 AM

Page 1

Work Order ID: 50235

Parent Item: D2857-1RevB

Parent Item Name: Hinge Bracket

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	36.0000	4.6053			



6061-T6 Bar 2.00 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

36

105838

12

110936

24

110936

5.200

ML 09/07/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	50235
<b>Description: Hinge Bracket</b>		<b>Part Number:</b>	D2857-1
<b>Inspection Dwg: D2857 Rev: B</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

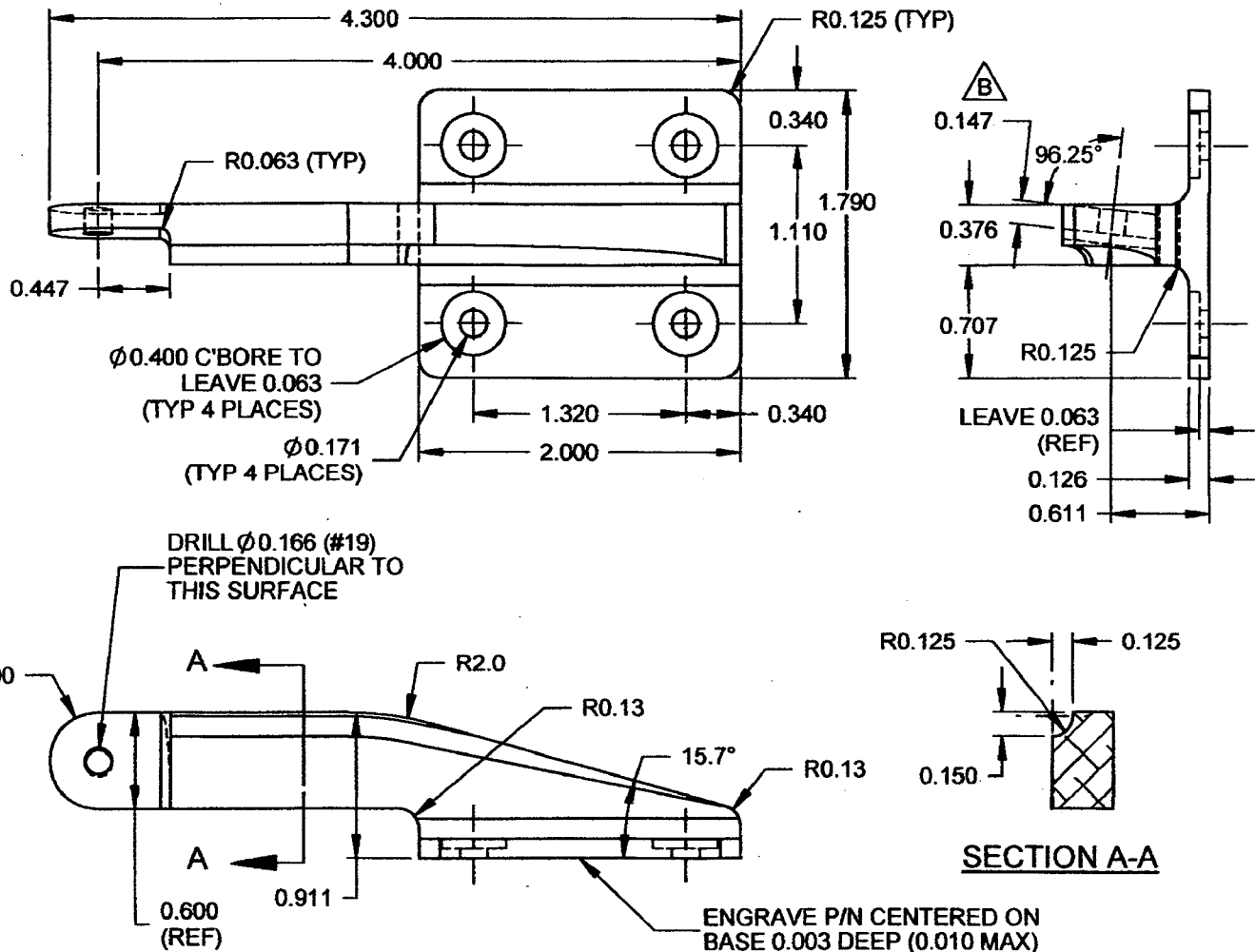
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.304	✓			
4.000	+/-0.010	4.000	✓			
0.340	+/-0.010	.345	✓			
1.110	+/-0.005	1.111	✓			
1.790	+/-0.010	1.794	✓			
1.320	+/-0.005	1.319	✓			
2.000	+/-0.010	2.004	✓			
0.340	+/-0.010	.341	✓			
0.447	+/-0.010	.449	✓			
Ø0.171	+0.005/-0.000	.174	✓			
0.147	+/-0.010	.148	✓			
0.376	+/-0.010	.376	✓			
0.126	+/-0.010	.119	✓			
0.063	+/-0.010	.062	✓			
Ø0.166	+0.005/-0.000	.166	✓			
0.911	+/-0.010	.915	✓			
0.600	+/-0.010	.605	✓			
0.125	+/-0.010	.128	✓			
0.150	+/-0.010	.147	✓			

<b>Measured by:</b>	SP	<b>Audited by:</b>	JL	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09/07/26	<b>Date:</b>	09/07/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

**DART**

DESIGN KE	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2857</b>	REV. B SHEET 1 OF 1
DATE <b>06.08.28</b>	TITLE <b>HINGE BRACKET</b> SCALE 1:1		
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

**RELEASED**  
06-10-13

**D2857-1 HINGE BRACKET**  
**D2857-2 OPPOSITE**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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